

# Work Order ID 57057

March 18, 2010 11:36:13 AM



Page 1

Item ID: DSI 9505-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Conversion Installation, RH

Start Date: 3/18/10 Start Qty: 2.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI9505-012  
CHG001

0.00

8/10/19

Pro→

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

10-3-19 sf (2x)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo



0.00

8/10/19

(2)



Dart Aerospace Ltd

W/O: ,		WORK ORDER CHANGES					
DATE	STEP		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		DS19505-011 <sup>c-012</sup> PROCEDURE CHANGE					
10/3/19	# 100	Remove D 2258-300 (Lable) From wlo + Bom. Pre installation on D3713-041 / 042.	DA	10.03.19			8 10/03/19
		ADD copy of new Bom for Ref. ? Add DS1 Eng. A to the change box <i>perm change</i>					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Work Order ID 57057**

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Page 2

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Start Date: 3/18/10 Start Qty: 2.00



Required Date: 3/19/10 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI9505-012

Location:

PPP rev: *only**10/3/19**(2)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

*02/10/31/19**1005-15*



# Picklist Print

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Page 1

Work Order ID: 57057

Parent Item: DSI 9505-012

Parent Item Name: Basket Conversion Installation, RH

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM  
label DD 10.03.18 verified by:JLM

IPP Rev:B add

Start Date: 3/18/10

Required Date: 3/19/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-11A x6  
Bolt

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST351

250

109927

29

110865

170

14820

51

Purchased

No

110

Each

766.0000

6.0000

12

10-3-19

sf

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST359

766

104016

703

16895

63

Purchased

No

110

Each

0.0000

24.0000

6

M113288 10-3-19 sf

AN960JD10 x12  
Washer

AN960JD416 x6  
Washer

M113706 10-3-19 sf

2X

QSI 017 sf



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Page 2 *14*

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IPP Rev:B add

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Required Date: 3/19/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2258-300		Manufactured	No			110	Each	11.0000	2.0000			

Label

*aka installed on*

*DS7B-042 B56576  
B56581*

Warehouse  
Location  
Main Warehouse  
ST505  
42011  
55718

Loc Qty Loc Code

11

2

9

D3713-042 *x1*

Manufactured No

Lid Assembly

D3723-1 *x6*

Manufactured No

Pushing

110

Each

0.0000

2.0000



*B56578*

*B56581  
10-3-19 sl*

110

Each

28.0000

12.0000



*10-3-19 sl*

*B57043*

*6X*

Warehouse  
Location  
Main Warehouse  
ST086  
38229  
48627

Loc Qty Loc Code

28

7

21

*6*

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Shop Packet Print

Page 2



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Page 3 14

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Required Date: 3/19/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3725-1 x2  
Hoop

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST086	24	
45575	1	
50939	8	
51118	15	

Manufactured No

110 Each 15.0000 6.0000

10-3-19 sl

D3748-1 x3  
Hinge Half

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	15	
46894	15	

Manufactured No

110 Each 13.0000 4.0000

4

A34689 10-3-19 sl

D3757-1 x2  
Blanking Plate

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST515	13	
51119	13	

6

10-3-19 sl (2x)

4

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Page 3



# Picklist Print

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IPP Rev:B add

Start Date: 3/18/10

Required Date: 3/19/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3

*x6*



Nut



*10-3-19 SL*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

2167

110844

35

111274

27

111668

58

112314

285

112385

42

113523

20

113537

700

113644

1000

110

Each

2,263.000 6.0000



*10-3-19 SD*

*24*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

2263

102552

6

104248

6

110507

184

111827

113

113422

954

114108

1000

*6*

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**DART SERVICE INSTRUCTION**

#8

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. G &  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 2  
REF. TCCA STC SH96-120, FAA STC SR00696NY & EASA STC EASA.IM.R.S.01242

**Purpose:**

To provide the parts and instructions for converting a D205-541-043/-044 basket to a D205-541-045/-046 basket.

**Parts List:**

Qty -011	Qty -012	Part Number	Description
X		DSI 9505-011	Basket Conversion Kit, LH
	X	DSI 9505-012	Basket Conversion Kit, RH
1		D3713-041	Lid Assembly, LH
	1	D3713-042	Lid Assembly, RH
3	3	D3748-1	Hinge Half
2	2	D3725-1	Hoop
2	2	D3757-1	Blanking Plate
1	1	D2258-300	Placard (Pre-installed on D3713-041/-042)
6	6	AN3-11A	Bolt
12	12	NAS1149D0363J	Washer (or AN960JD10)
6	6	MS21042L3	Nut (or MS21042-3)
3	3	AN4-20A	Bolt
6	6	NAS1149D0463J	Washer (or AN960JD416)
6	6	D3723-1	Bushing
3	3	MS21042L4	Nut (or MS21042-3)

**Procedure:**

1. Remove and retain D2332-041 Prop Arm and attaching hardware.
2. Remove and retain D2530 Handle, D2535 Springs, D2537 Bushings, and attaching hardware.
3. Separate lid from hinge on D205-541-043/-044 by removing 2 x AN4-7A bolts.
4. Trim existing hinge pieces flush with the top frame of the basket base as shown in Figure 1
5. Break tack welds between mesh and frame in top of basket base as shown in Figure 1
6. Cut basket down by 4.00" (102mm) per Figure 1.
7. Trim frame for installation of basket hoops per Figure 1.
8. Deburr stubs and basket base top frame.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.03.16  
CERT. NO.: SH96-120  
ISSUE NO.: 3

A	NEW ISSUE	RF	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9505	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MODIFIED UTILITY-BASKET	NTS
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1000-10

1000-1000

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1000-1000

# REFERENCE ONLY

9. Install D3725-1 Hoops and stubs. Tig weld stubs and hoops to existing basket base top frame using ER316L filler rod per AWS D17.1 2001 Class "A" per Figure 2.
10. Tig weld base top frame to existing basket base using ER316L filler rod per AWS D17.1 2001 Class "A" per Figure 2.
11. Trim mesh and tack weld every available stand to new frame.
12. Locate D3713-041/-042 Lid Assembly on modified base per Figure 3 Use 0.20" (5mm) thick spacers between the lid and the modified base for proper positioning. Position 3 x D3748-1 Hinge Half on modified base and weld in place using 0.125" (3mm) thick spacers between upper and lower hinge half per Figure 3.
13. Transfer Ø0.257 (F drill) hinge holes in D3713-041/-042 Lid Assembly to D3748-1 Hinge Halves.
14. Touch up paint on modified base per ICA-D205-541.
15. Attach D3713-041/-042 Lid Assembly to modified base using AN4-20A bolts and associated hardware per Figure 4.
16. Install D2332-041 Prop Arm and attaching hardware per Figure 4.
17. Install D2530 Handle, D2535 Springs, D2537 Bushings, and attaching hardware per Figure 5.
18. Install D3757-1 Blanking Plates and attaching hardware per Figure 6.
19. Lift and drop lid to ensure lid closes properly on modified base.
20. Install a placard (not provided) next to the Product ID label to indicate "Basket has been modified to D205-541-045/-046 configuration per DSI 9505".
21. If desired, the D205-541-047/-048 steps can be installed on the modified basket base per section 3.2 of D205-541 Rev. G, or later approved revision.
22. Modified basket can be re-installed on the aircraft per section 3.1 of D205-541. Update Weight and Balance per section 4 of D205-541.

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BY:	<i>[Signature]</i>
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MFG. APPR.	<i>[Signature]</i>	DSI 9505	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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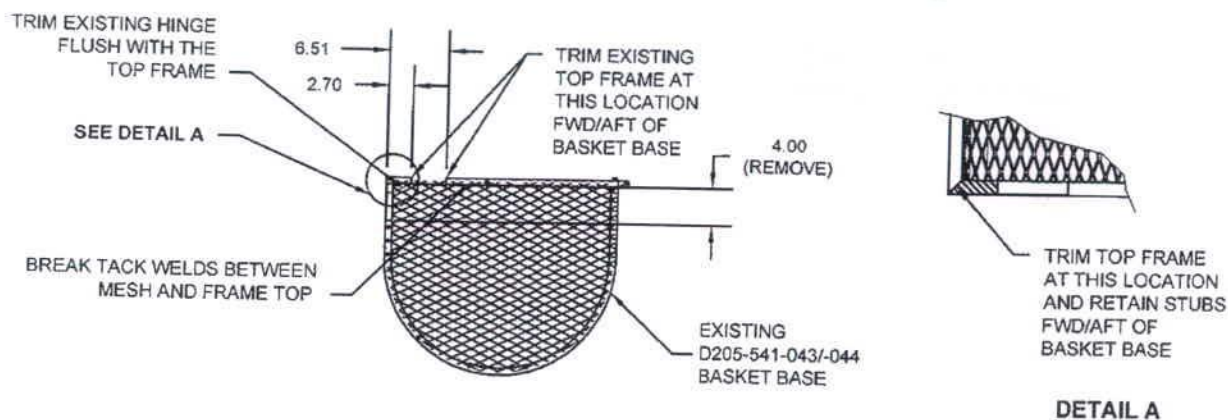


FIGURE 1. - FRAME TRIM DETAIL

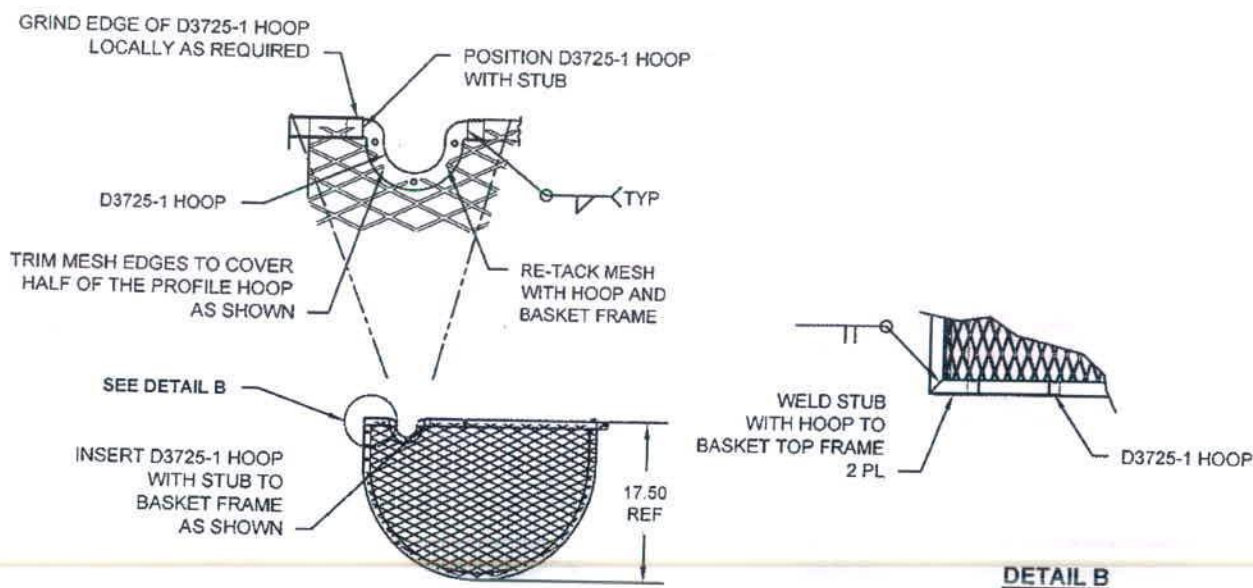


FIGURE 2. - HOOP WELDING DETAIL

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DAO # 01-O-01

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MFG. APPR.	<i>[Signature]</i>	DSI 9505	SHEET 3 OF 5
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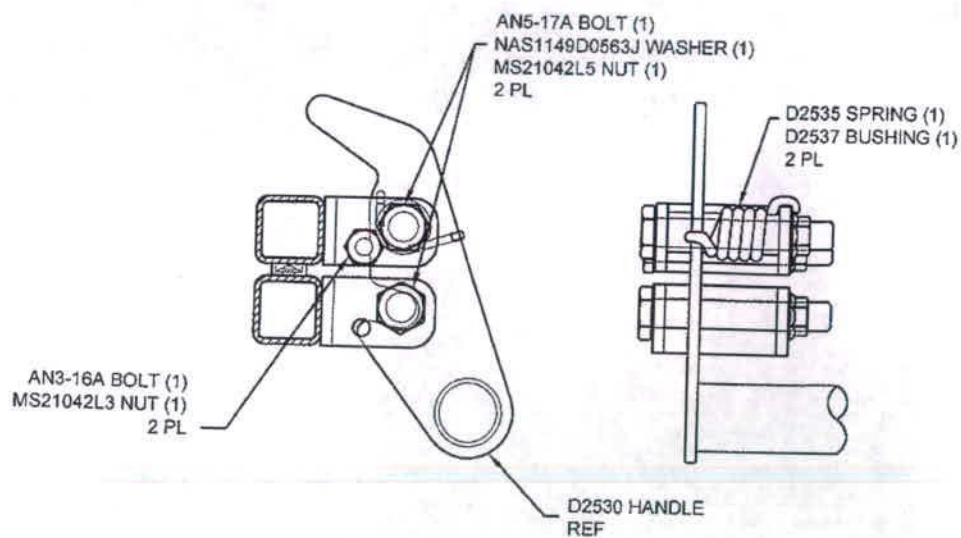


FIGURE 5. - LATCH INSTALLATION

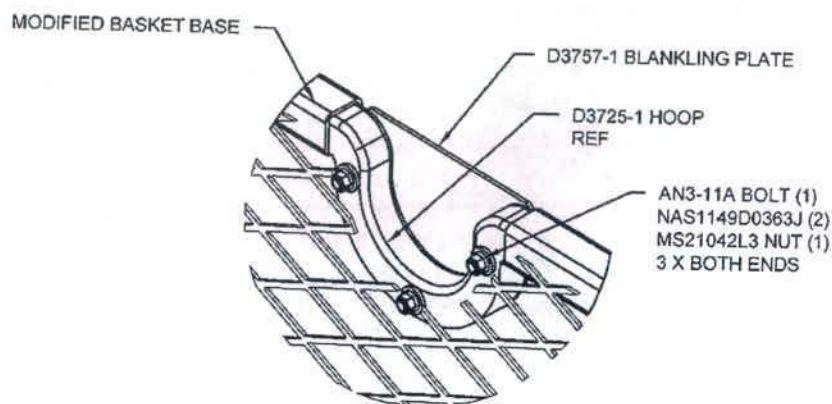


FIGURE 6. - D3757-1 BLANKING PLATE INSTALLATION

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MFG. APPR.	<i>[Signature]</i>	DSI 9505	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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